

Work Order ID 70556

Friday, June 10, 2011 3:42:39 PM



Page 1

Item ID: D350-589-011

Accept



Setup Start



Revision ID:

Stop



Item Name: Side Door Latch Modification

Start Date: 6/10/2011 Start Qty: 5.00



Cust Item ID:

Required Date: 6/15/2011 Req'd Qty: 5.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

6-10-11

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

INN-D350-589

E

100

0.00



DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy blue file and type label as per PPP D350-589-011 CHG002

Sublet

11-6-14

105

0.00



Pick Kit

Packaging

Memo

0.00

Packaging

11/6/14

110

0.00



QC4- 100% Inspect kits for completeness

QC

Memo

0.00

Quality Control

Sublet

75

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng		Sign & Date			

NOTE: Date & initial all entries

[illegible]

Page 2

[illegible]

Abstract

Reference:

[illegible]

**Insp.
Stamp**

0.00

Packaging

0.00

Packaging

Memo

Packaging

Identify and pack for shipping as per QSI 014

0.00 REO F

11/4/16 SS

0.00

[illegible]

QC21- Final Inspection - Work Order Release

0.00

QC

Memo

Quality Control

11-06-16

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng		Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Friday, June 10, 2011 3:42:46 PM

Page 1

Work Order ID: 70556

Parent Item: D350-589-011

Parent Item Name: Side Door Latch Modification

Start Date: 6/10/2011

Required Date: 6/15/2011

Start Qty: 5.00

Required Qty: 5.00

Comments: IPP F02.08.29 Removed D2587 Plug KJ
ALL AT CHANGE 002

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
AN960JD10 Washer	NAS1149D0363J	Purchased	No			105	Each	0.0000	3	15			
D2237 Striker Plate		Manufactured	No			105	Each	37.0000	3	15			
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST009				37		15			
				66139				37		15			
D2583 Latch Bracket		Manufactured	No			105	Each	22.0000	3	15			
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST017				22		15			
				69512				22		15			
D2585 Mounting Channel		Manufactured	No			105	Each	40.0000	3	15			
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST017				40		10			
				66142				10		5			
				69536				30					

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng		Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Work Order ID: 70556

Parent Item: D350-589-011

Parent Item Name: Side Door Latch Modification

Start Date: 6/10/2011

Required Date: 6/15/2011

Start Qty: 5.00

Required Qty: 5.00

D2586

Manufactured No

105

Each

69.0000

3

15



Door Latch

Location

Loc Qty

Loc Code

ST204

69

64774

69

D2587

Manufactured No

105

Each

19.0000

1

5



Door Slug, 350 Hinge

Location

Loc Qty

Loc Code

ST017

19

66836

19

D2589

Manufactured No

105

Each

98.0000

1

5



Keys, Key Chain, 350 Hinge

Location

Loc Qty

Loc Code

ST018

98

58194

98

MS20470AD4-5

Purchased

No

105

Each

968.0000

6

30



Rivet, Universal Head

Location

Loc Qty

Loc Code

ST319

968

116893

968

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

Picklist Print

Friday, June 10, 2011 3:42:46 PM

Work Order ID: 70556



Parent Item: D350-589-011



Parent Item Name: Side Door Latch Modification

Start Date: 6/10/2011

Required Date: 6/15/2011

Start Qty: 5.00

Required Qty: 5.00

MS21042L3 Purchased No

105 Each

2,307.000 3



Nut



15

Location

Loc Qty

Loc Code

ST300

2307

108701

12

116391

9

116549

586

117441

800

117601

400

117885

500

15

MS27039-1-15 Purchased No

105 Each

65.0000 3



Screw



15

11/6/14 50

Location

Loc Qty

Loc Code

ST292

65

116916

65

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng		Sign & Date			

NOTE: Date & initial all entries

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52.4 PARTS LIST

589 -011	589 -041	589 -042	589 -043	Part Number	Description
X				D350-589-011	SIDE DOOR LATCH MODIFICATION KIT
	X			D350-589-041	SIDE DOOR ASSEMBLY, LH AS 350
		X		D350-589-042	SIDE DOOR ASSEMBLY, RH AS 350/355
			X	D355-589-043	SIDE DOOR ASSEMBLY, LH AS 355
	1			D2991-1	Door
		1		D2991-2	Door
			1	D2991-3	Door
3	3	3	3	D2237	Striker Plate
	1	1	1	D2464-1700	Seal
3				D2583	Latch Bracket
3	3	3	3	D2585	Latch Clamp
3	3	3	3	D2586	Latch
1				D2587	Plug
1	1	1	1	D2589	Keys, Key Chain
	3	3	3	D2621	Latch Plate
	2**	2**	2**	D2992-1	Doubler
	1	1	1	D3085-041	Prop Assembly
	1*	1*	1*	D3015-3	Locknut
	1*	1*	1*	D3081-1	Prop Hinge
	1*	1*	1*	D3082-1	Clip
	1*	1*	1*	D3084-1	Prop Arm
	1*	1*	1*	AN4-5A	Bolt
	3*	3*	3*	AN960JD10	Washer
	3*	3*	3*	AN960JD10L	Washer
	2*	2*	2*	AN960JD416	Washer
	1*	1*	1*	AN960JD516L	Washer
	3*	3*	3*	MS21042L3	Nut (or MS21042-3)
	1*	1*	1*	MS21042L4	Nut (or MS21042-4)
	3*	3*	3*	MS27039-1-13	Screw
	1*	1*	1*	SL69-BS	Ball Stud
	6	6	6	AN3-4A	Bolt
3	3	3	3	AN960JD10	Washer
3	9	9	9	MS21042L3	Nut (or MS21042-3)
6	6	6	6	MS20470AD4-5	Rivet
3	3	3	3	MS27039-1-15	Screw

* Reference only. Included in D3085-041 Prop Assembly listed above.

** Reference only. Included in D2991-1/-2/-3 Doors listed above.

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